







Date: Monday, 12/10/2007 12:00:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAM LOCK SHAFT
Job Number : 36215	
Estimate Number : 11344	
P.O. Number : 12/10/2007 S.O. No. :	Part Number : D33693
This Issue : NC	Drawing Number : D3369 REV A
Prsht Rev. : 11	Project Number : N/A
First Issue : Type : MACHINED PARTS	Drawing Revision : A
Previous Run	Material :
Written By : <i>HA 07.12.10</i>	Due Date : 12/24/2007 Qty: 20 Um: Each
Checked & Approved By : <i>HA 07.12.10</i>	
Comment : Est: A 05.01.05 New issue KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M303R0375 303 Round Bar 0.375"
	
Comment: Qty.: 0.1575 f(s)/Unit Total : 3.1500 f(s) Material: AISI 303 SS Rod Ø0.375 (M303R0.375) Identify for D3369-3 Batch: <i>M100817</i> <i>HA</i> <i>08/01/24</i> <i>(20)</i>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	
Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA487 and Dwg D3369 <i>HA / ml</i> <i>08/01/24</i> <i>(20)</i>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>HA / ml</i> <i>08/01/24</i> <i>(20)</i>	
4.0	BAND SAW BAND SAW
	
Comment: <i>HA 01.26</i> BAND SAW <i>MANUAL MILL</i> Machine D3369-3 as per Folio FA487 and Dwg D3369 Deburr Identify as D3369-3 <i>J.F.</i> <i>08/01/27</i> <i>(20)</i>	
5.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.F.</i> <i>08/01/27</i> <i>(20)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/10/2007 12:00:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAM LOCK SHAFT

Job Number: 36215

Part Number: D33693

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2F 08/01/28

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/28 (+20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 88

8/1/28 (+20) SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/01/28

Job Completion



2008/1/28
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36215
Description: Cam Lock Shaft		Part Number: D3369-3
Inspection Dwg: D3369 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

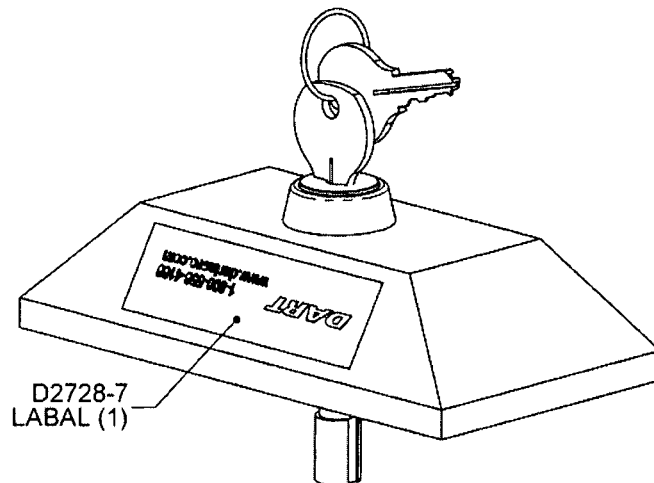
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.725	+/-0.010	1.727	✓			
0.540	+/-0.010	.541	✓			
0.111	+/-0.010	.111	✓			
0.037	+/-0.010	.034	✓			milling
Ø0.374	+0.005/-0.000	Ø.375	✓			
0.060	+/-0.010	.060	✓			
0.175	+/-0.010	.175	✓			
0.015 x 45°	+/-0.010	0.015 x 45°	✓			
0.015	+/-0.010	0.0195	✓			
10-32 UNF	N/A	M = .213	✓			10-32 UNF 3A
0.037	+/-0.010	0.036	✓			
0.120	+/-0.010	.126	✓			milling
0.899	+/-0.010	.899	✓			

Measured by: M.A. / [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/01/24	Date: 08/01/24	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM [Signature]	[Signature]



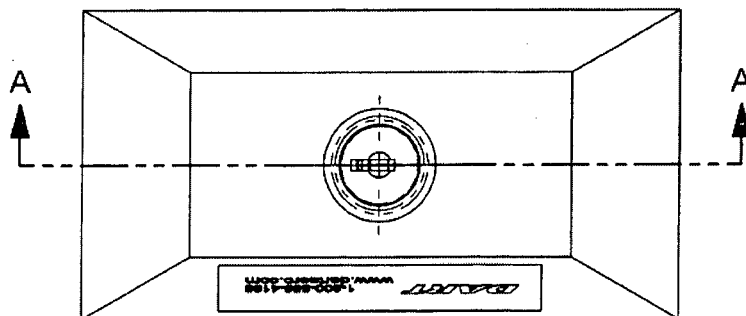
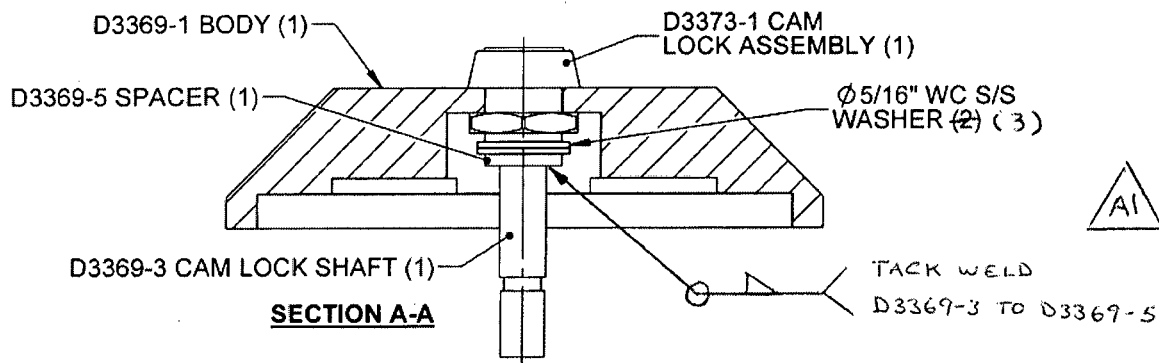
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CHECKED R	APPROVED MS	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	



BATTERY LOCK SHOWN LOCKED WITH KEY

RELEASED

05/02/11



D3369-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004

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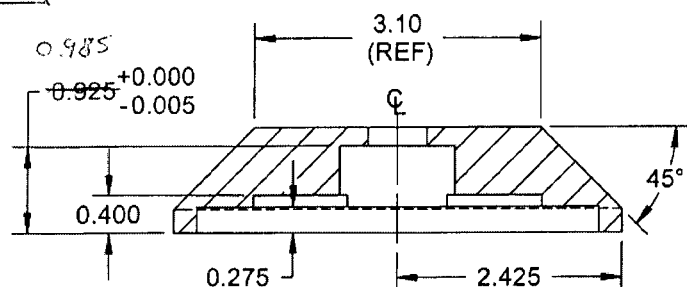
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ADD TACK WELD
0.865 WAS 0.925

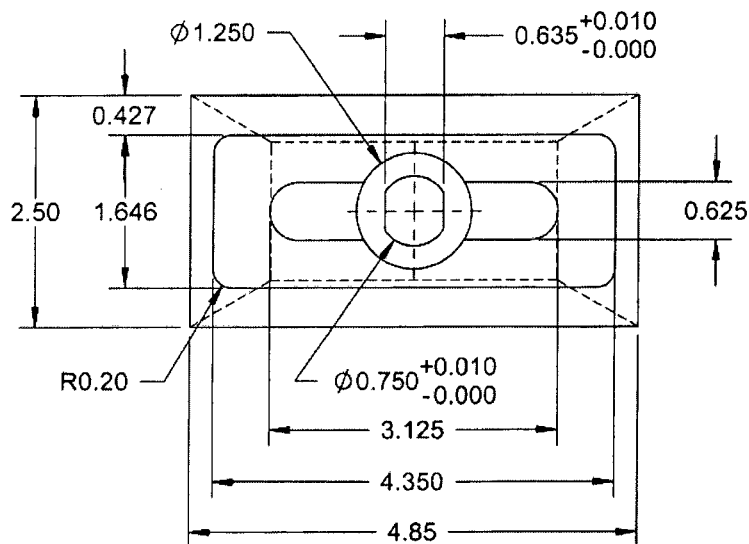
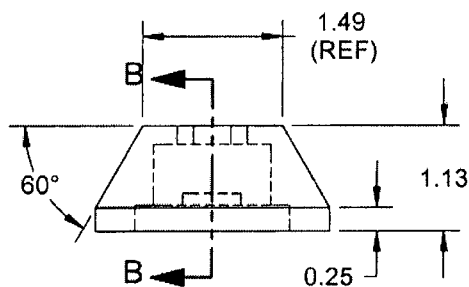
AI 05/02/11



DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED MB	DRAWING NO. D3369	REV. A SHEET 2 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:2



SECTION B-B



RELEASED

05/02/11

D3369-1 BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

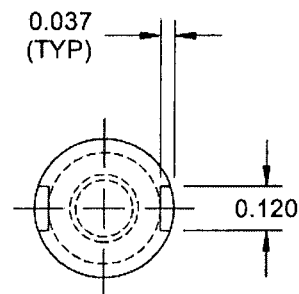
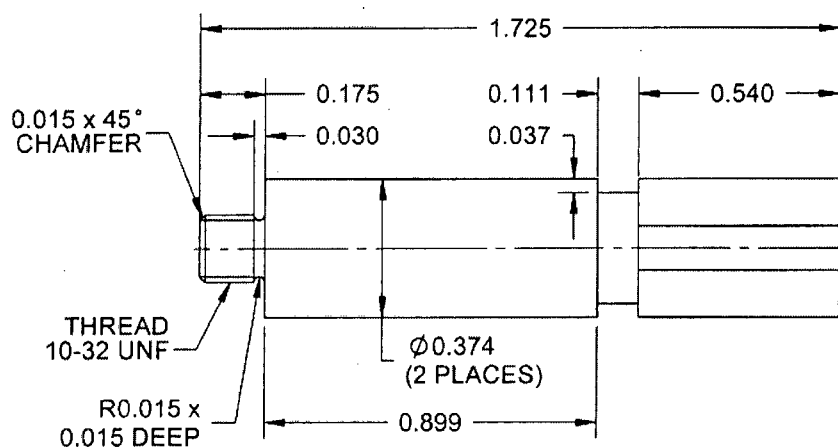
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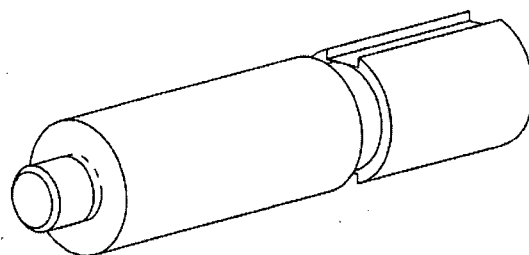
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 3 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1



RELEASED
[Signature]
05/02/11



D3369-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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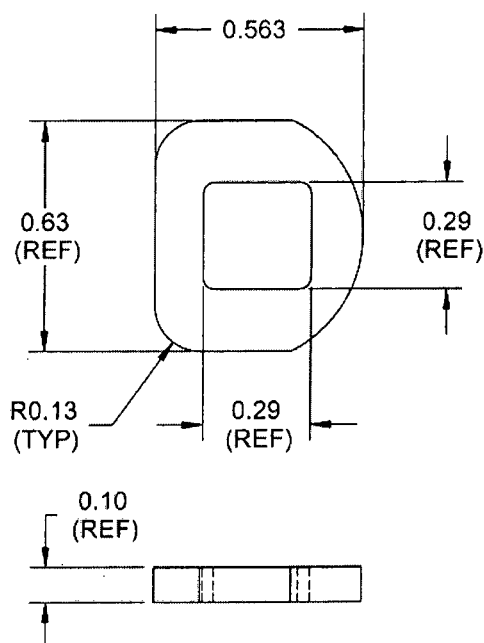
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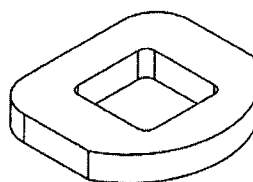
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CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
JS

05/02/11



-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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